Work Order ID 116127

Friday, April 04, 2014 2:04:05 PM

116127

Item ID: D4410-7 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Conduit

Start Date: 4/04/14 **Start Qty:** 4.00 *4*

Required Date: 4/04/14 **Req'd Qty:** 4.00 *4*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** MCJ **Date:** 14-04-10 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D4410	REV B								
100		0.00							
100						4			FF 14-04-28
Small Fab	**Memo**	0.00							
Small Fab	BEND AS PER DWG								
	DEBURR								
110	QC5- Inspect part completeness to step on W/O	0.00							DAS 27 9-89
110						4			14/4/29
QC	**Memo**	0.00							
Quality Control									
120	Identify as per dwg & Stock Location: WIP (01)	0.00							
120						4		CL	14-4-29
Packaging	**Memo**	0.00							
Packaging									

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Item ID: D4410-7
Revision ID:
Item Name: Conduit

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Start Date: 4/04/14 **Start Qty:** 4.00 *4*
Required Date: 4/04/14 **Req'd Qty:** 4.00 *4*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	**Memo**	0.00							
Quality Control									

4 | 4 | 30

4-04-29

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

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Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

Friday, April 04, 2014 2:04:04 PM

Work Order ID: 116127 *116127*

Parent Item: D4410-7 *D4410-7*

Parent Item Name: Conduit

Start Date: 4/04/14 **Required Date:** 4/04/14

Start Qty: 4.00 **Required Qty:** 4.00

Comments: IPP REV:A NEW ISSUE 11-11-02 JLM VERIFIED BY:DD IPP
REV:B AS PER PB6 12-08-13 JFS VERIFIED BY:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.625W.049		Purchased	No				f	188.5000		7.157895			
M6061T6T0.625W.049									**			FF 14-04-28	
6061-T6 RD Tube .625 x.049W													

Location	Loc Qty	Loc Code	
MAT014	188.5		
124069	4		
m127600	184.5		7.1578

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

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Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

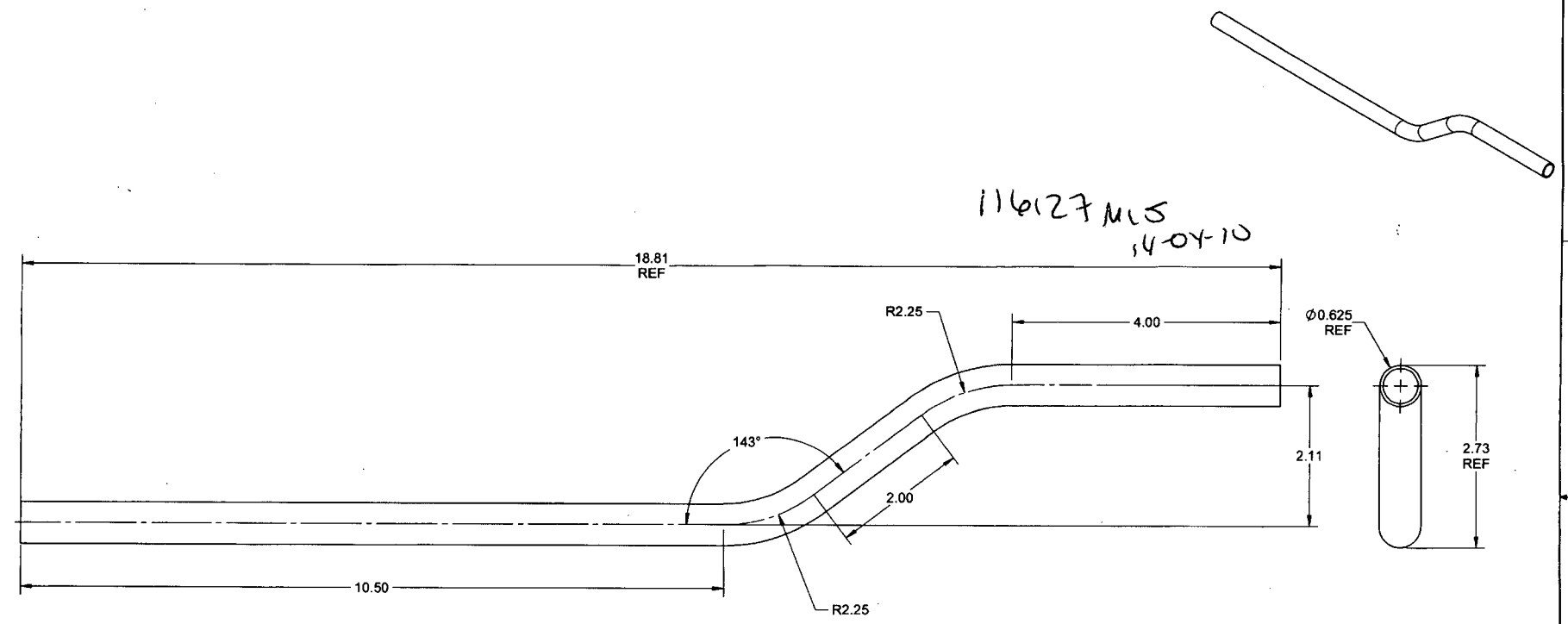
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☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other



D4410-7 CONDUIT

RELEASED
2014 -04- 04

NOTES:
1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING PER
WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
REF. DART SPEC. M6061T60.625W.050
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 0.17 lbs

APPROVED

DESIGN	VS
DRAWN	VS
CHECKED	DC
MFG. APPR.	JFS
APPROVED	HS
DE APPR.	DS
DATE	14.02.20

DART AEROSPACE USA, INC.
KENT, WA

DRAWING NO. D4410 REV. C
SHEET 8 OF 12
TITLE CO-PILOT COLLECTIVE HEAD
SCALE NTS

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DART AEROSPACE LTD

DART AEROSPACE

Description: Conduit Work Order: 116127

Inspection Drawing: D4410 Rev: B Part Number: D4410-7

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.50	± 0.30	10.50	✓		S-Fab-07	
143°	1°	143.°	✓		SFab-05	
2.00	±0.30	2.00	✓		SFab-07	
4.00	± 0.30	4.00	✓		SFab-07	
19.81	± 0.30	19.81	✓		SFab-07	
2.11	± 0.30	2.14	✓		SFab-08	
2.73	± 0.30	2.77	✓		SFab-08	

Measured by:	Checked By: DAS 30 9-89	QC inspector: DAS 27 9-89	Engineering Approval (*if necessary*)
FF			
Date 14-04-28	Date 14/04/28	Date 14/4/28	Date